

Work Order ID 59875

June 21, 2010 10:38:22 AM



Page 1

Item ID: D2600-1-160

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Round 3" 206

Start Date: 6/15/10 Start Qty: 35.00



Cust Item ID:

Required Date: 6/21/10 Req'd Qty: 35.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CY

Date: 10/6/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2600 | Rev D1 |

| | | |
|-----|--|------|
| 100 | | 0.00 |
|-----|--|------|



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12127 ☐a) Extrude as per Dwg D2600 ☐b) Material:
6061-T6 (QQ-A-200/8) ☐c) Minimum yield tensile strength = 35 ksi ☐d)
Minimum ultimate tensile strength = 40 ksi ☐e) Minimum elongation = 8% ☐f)
Order at 160" long ☐g) Bon L Canada Inc. tool #

CY 10/6/21 (35)

| | | |
|-----|--|------|
| 110 | Receive & Inspect for Damage & Mat'l Certs | 0.00 |
|-----|--|------|



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

10/7/21 (39)

| | | |
|-----|------------------------------------|------|
| 120 | QC6- Inspect dimensions to drawing | 0.00 |
|-----|------------------------------------|------|



QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2600 for compliance page attached Check hardness
with Webster tester

count
(+39)

Sidoslay

Sidoslay

Work Order ID 59875

Tuesday, June 15, 2010 1:06:44 PM

Page 2

Item ID: D2600-1-160

Accept

Revision ID:

Item Name: Extrusion Round 3" 206

Start Date: 6/15/2010 Start Qty: 80.00

Required Date: 6/21/2010 Req'd Qty: 80.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

x39

BE 10/08/03

10/08/04

ME
10-8-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 15, 2010 1:06:49 PM

Page 1

Work Order ID: 59875

Parent Item: D2600-1-160

Parent Item Name: Extrusion Round 3" 206



Start Date: 6/15/2010

Required Date: 6/21/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D: ☐ 02.09.05 ☐ Added DSK 066 KJ/RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--|--------------|---------------|----------------|--------|
| D2600-1-160P  Extrusion Round 3" 206 | | Purchased | No | | | 110 | Each | 0.0000 | 1  | 80 | | 6/17/29 | (39) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 1 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |
| A | 97.01.21 | NEW ISSUE | |
| B | 97.09.09 | CHANGE MATERIAL SPEC. | |
| C | 98.04.16 | ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO. | |
| D | 98.08.20 | INCREASE MIN. UTS TO 40 KSI | |
| DI | 01.04.17 | ADD PART NUMBERS + DIE NUMBERS <i>4 GP</i> | |

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59875

BJO-6-18

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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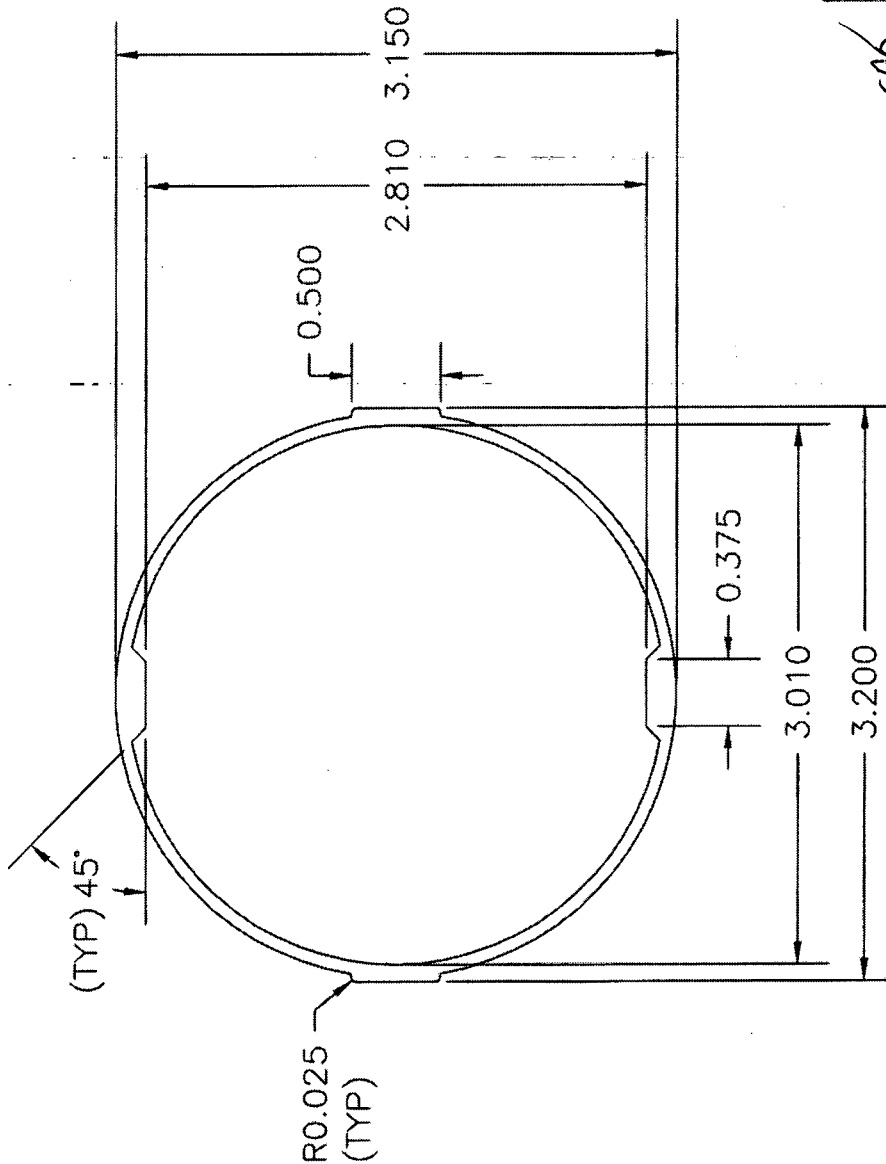
NOTE: Date & initial all entries



| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>DB</i> | DRAWN BY <i>DB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 2 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.25 DS

W059816



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 16.0" LONG)



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

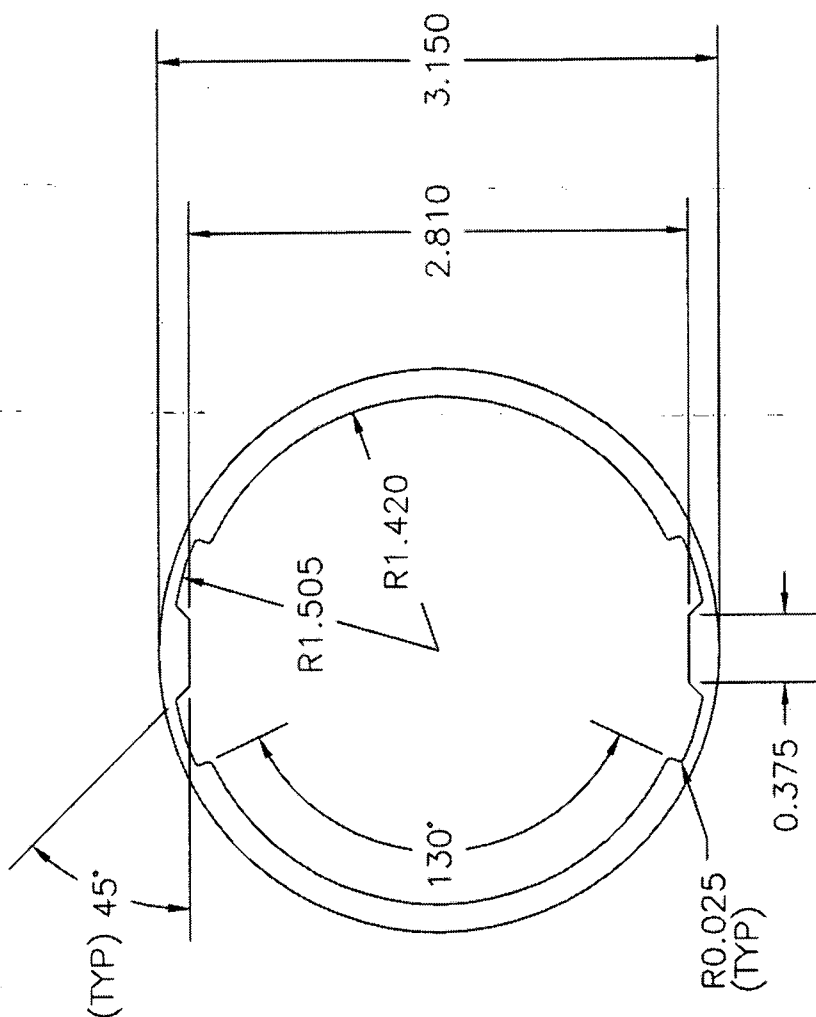
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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|----------------------|-----------------------|---|------------------------|
| DESIGN <i>DM</i> | DRAWN BY <i>DM</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>KE</i> | DRAWING NO. D2600 | REV. D SHEET 3 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.25 DS



W/O 59875

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120 LONG)



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

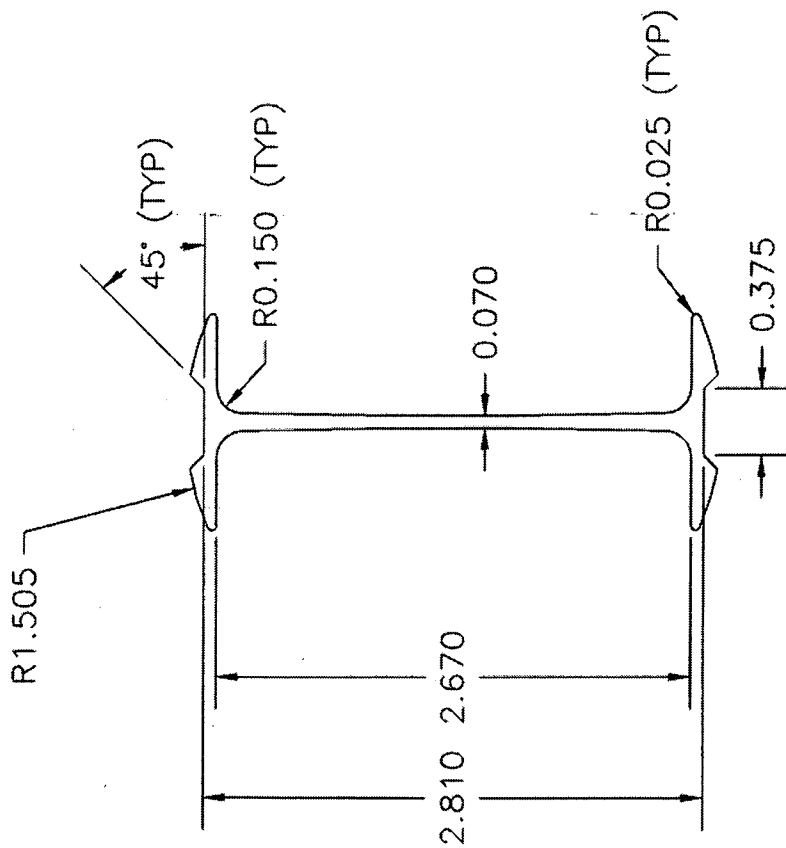
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN <i>MB</i> | DRAWN BY <i>MB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>KE</i> | DRAWING NO. D2600 | REV. D SHEET 4 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.23. DS



W16 59815

D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

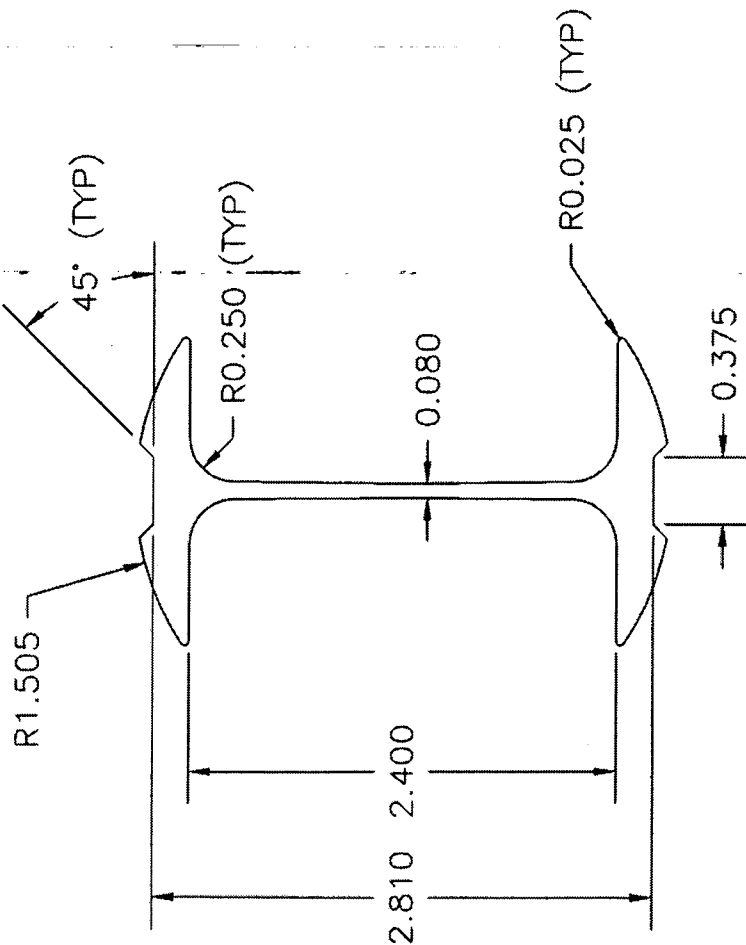
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 5 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98 8 25 DS



W65875

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(Eg. D2600-7-125 IS 125" LONG)



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST
MANIFEST DATE
07-28-10
MANIFEST NUMBER
682087
SALES ORDER NUMBER
64085

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

CREDIT REP
DHILLON, ROBE

SALES REP

LOCATION TRAILER NUMBER SALESMAN
PIC JODEE 59358

FIELD SALES REP
Bates M
905-427-2235

CUST SERVICE REP
Burton D
905-427-2227

ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

TERMS / FREIGHT
O / P

CUSTOMER ID 46024 ORDER DATE 06/21/10 CUSTOMER PO NUMBER 12127

JOB BILL OF LADING NUMBER 08409451

| 46024 | | 06/21/10 | | 12127 | | ALLOY & TEMPER | | FINISH DESCRIPTION | | THIS SHIPMENT | | | UNIT | | QUANTITY DUE | |
|-----------------|-------------------------|----------|---------------------------|----------------------|-------------------|-------------------------|--|--------------------|--------------|---------------|--|--|------|-----|--------------|--|
| ITEM NO. | ORIGINAL ORDER QUANTITY | UNIT | PREVIOUS SHIPPED QUANTITY | MFG. PART NUMBER | LENGTH | FABRICATION DESCRIPTION | | NBR OF PKGS | GROSS POUNDS | NET QUANTITY | | | | | | |
| | | | | CUSTOMER PART NUMBER | CUTTING TOLERANCE | SHIPPING TOLERANCE | | | | | | | | | | |
| 01 | 1105 | LB | 0 | DAA-3-2 | 6061 /T6 | MILL | | 1 | 456 | 439 | | | LB | 666 | | |
| | 875 | FT | 0 | D2962150 | 150" | CERTIFICATE OF COMP | | | | 350.00 | | | FT | 525 | | |
| | 70 | PC | 0 | | +5/16 " | (+015-015,0080-0059) | | | | 28 | | | PC | 42 | | |
| LOT/TKT DETAIL: | | | | | | 64085010 / 365118 | | 1 | 456 | 439 | | | | 28 | PC | |
| 02 | 666 | LB | 0 | DAA-897121-3 | 6061 /T6 | MILL | | 1 | 747 | 723 | | | LB | 0 | | |
| | 665 | FT | 0 | D2600-1-190 | 190" | CERTIFICATE OF COMP | | | | 759.99 | | | FT | 0 | | |
| | 42 | PC | 0 | | +5/16 " | (+015-015,0048-0035) | | | | 48 | | | PC | 0 | | |
| LOT/TKT DETAIL: | | | | | | 64085020 / 365106 | | 1 | 747 | 723 | | | | 48 | PC | |
| 03 | 467 | LB | 0 | DAA-897121-1 | 6061 /T6 | MILL | | 1 | 511 | 492 | | | LB | 0 | | |
| | 467 | FT | 0 | D2600-1-160 | 160" | CERTIFICATE OF COMP | | | | 519.99 | | | FT | 0 | | |
| | 35 | PC | 0 | | +5/16 " | (+015-015,0040-0029) | | | | 39 | | | PC | 0 | | |
| LOT/TKT DETAIL: | | | | | | 64085030 / 365107 | | 1 | 511 | 492 | | | | 39 | PC | |
| | | | | | | | | 3 | 1714 | 1654 | | | LB | | | |
| | | | | | | | | | | 1629.98 | | | FT | | | |
| | | | | | | | | | | 115 | | | PC | | | |
| | | | | | | | | TOTALS | | | | | | | | |

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the contract of 1838 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE

1

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

DATE OF DELIVERY

DRIVER

CUSTOMER ACK / STATEMENT OF GOODS DELIVERED AND CONDITION

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

| Cert Date | Cert No | Sales Order | Page |
|-----------|----------|-------------|---------|
| 07/28/10 | 208425 | 64085 | 1 |
| Part No | B/L No | Lot | Date |
| 12127 | 08409451 | 64085030 | 7/28/10 |

| Sold To | Ship To |
|---|---|
| 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 | 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 |

| Item No | Part No | Item Description | Cust Part |
|-------------------------------|--------------|-------------------|--------------|
| 3.000 | DAA-897121-1 | 160" Mill 6061 T6 | D2600-1-160 |
| Gross Weight | 511 LBS | | |
| Net Qty | 492 LB | 39 PC | 520 FT 1 PKG |
| Specification | | Die Desc | |
| AMS-QQ-A-200/8 & ASTM B221-08 | | | |

Mechanical Tests:

| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend/Drift HREW |
|----------|-------------------|-----------------|-------------|--------------|-----------------|
| 1 | 300.0 / 43.5 | 269.9 / 39.2 | 10.0 | .0 | 91 |

Chemical Analysis:

| SI | FE | CU | MN | MG | CR | ZN | TI |
|-----|-----|-----|-----|-----|-----|-----|-----|
| .64 | .29 | .24 | .05 | .88 | .06 | .08 | .01 |

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Ryan Petersen, QA Manager Signature Aluminum Canada Inc